

Date: Monday, 2/11/2008 11:38:36 AM
User: Kim Johnston

Process Sheet

9

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	R44 BEARPAW	
Job Number	37315A				
Estimate Number	12480				
P.O. Number	:		Part Number	D35291	
This Issue	2/11/2008	S.O. No. :	Drawing Number	D3529 REV A	
Prsht Rev.	NC		Project Number	N/A	
First Issue	/ /		Drawing Revision	A	
Previous Run	31589A		Material	:	
Written By	:		Due Date	2/28/2008 Qty: 12 Um: Each	
Checked & Approved By	:				
Comment	Est Rev:A New Issue 06-06-28 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MUHMWB10	UHMW 1" Black	
		Comment: Qty.: 1.2796 sf(s)/Unit Total : 15.3556 sf(s) Pick: blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000) Material: Black UHMW 1"(MUHMWB10) Batch: M105863 x6pcs only = 7.6776 sf(s)	J.L 08/02/25
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA645 and Dwg D3529 3-Deburr	J.L 08/02/25
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.L 08/02/25
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	8F 08/02/25
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8/3/11 SC	X/100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 11:38:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 37315A

Part Number: D35291

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/12

Job Completion



= 2008/3/11

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37315A
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

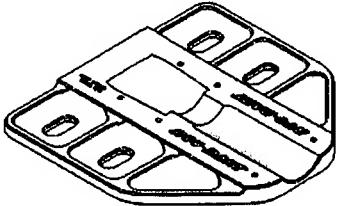
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.50	+/-0.030	5.500	✓			
B 0.07 x 45°	+/-0.030 x 0.5°	.073x45°	✓			
C R0.25	+/-0.030	.25	✓			
D 0.250	+/-0.010	.251	✓			
E 0.625	+/-0.010	.624	✓			
F 0.950	+/-0.010	.956	✓			
G 1.63	+/-0.030	1.620	✓			
H 12.14	+/-0.030	12.14	✓			
I 10.50	+/-0.030	10.530	✓			
J 5.70	+/-0.030	5.710	✓			
K 0.375	+/-0.010	.378	✓			
L 0.525	+/-0.010	.526	✓			
M 0.13 x 45°	+/-0.030 x 0.5°	.116x45°	✓			
N R0.50	+/-0.030	.50	✓			
O 12.76	+/-0.030	12.76	✓			
P 3.38	+/-0.030	3.38	✓			
Q 3.75	+/-0.030	3.752	✓			
R 5.187	+/-0.010	5.187	✓			
S 5.25	+/-0.030	5.252	✓			
T 7.13	+/-0.030	7.129	✓			
U Ø0.260	+0.006/-0.001	.260	✓			
V 0.30	+/-0.030	.308	✓			
W 0.93	+/-0.030	.928	✓			
X 1.30	+/-0.030	1.298	✓			
Y						

Measured by:	JL	Audited by:	SP	Prototype Approval:	N/A
Date:	08/02/05	Date:	08/02/05	Date:	N/A

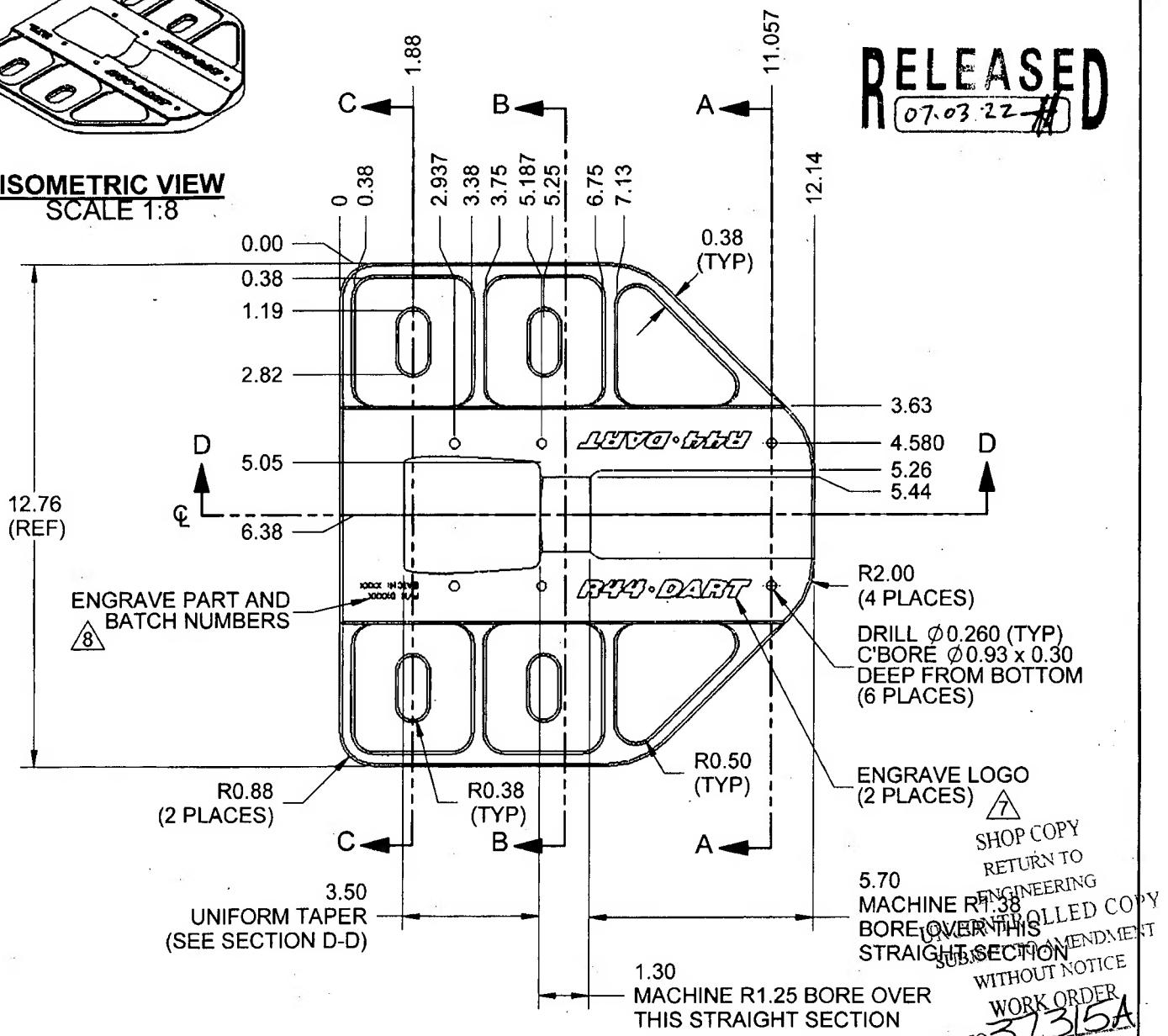
Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	SP

DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>-</i>	DRAWING NO. D3529
DATE 07.01.04		REV. A SHEET 1 OF 2
		TITLE R44 BEARPAW
		SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE



ISOMETRIC VIEW
SCALE 1:8

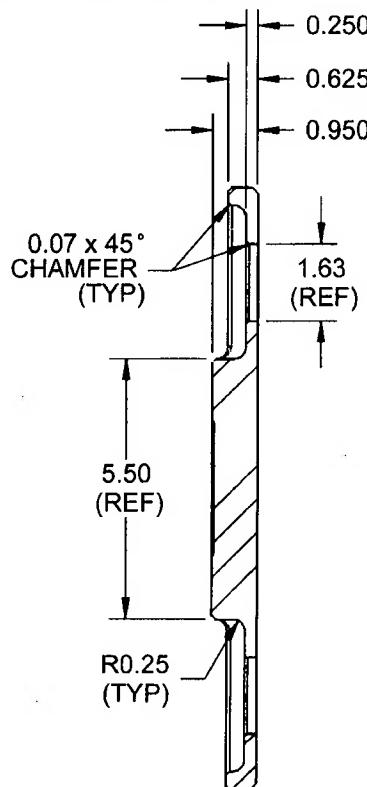
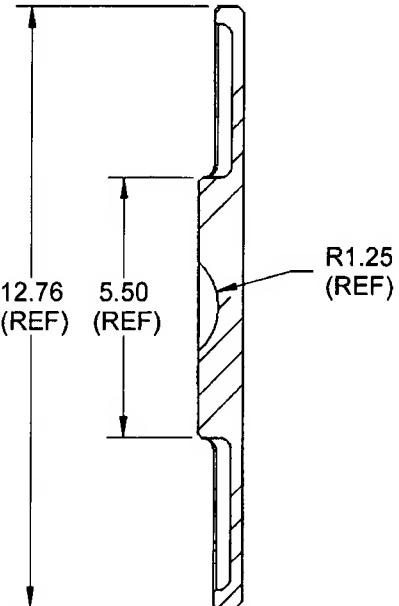
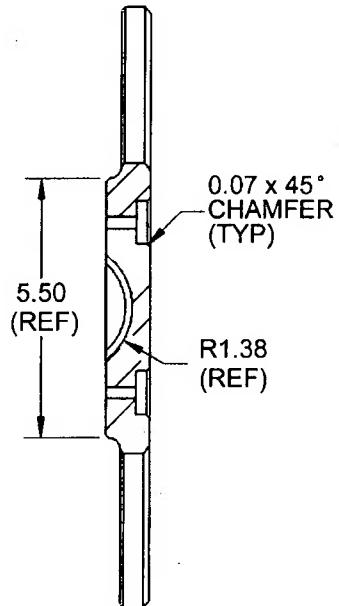


NOTES:

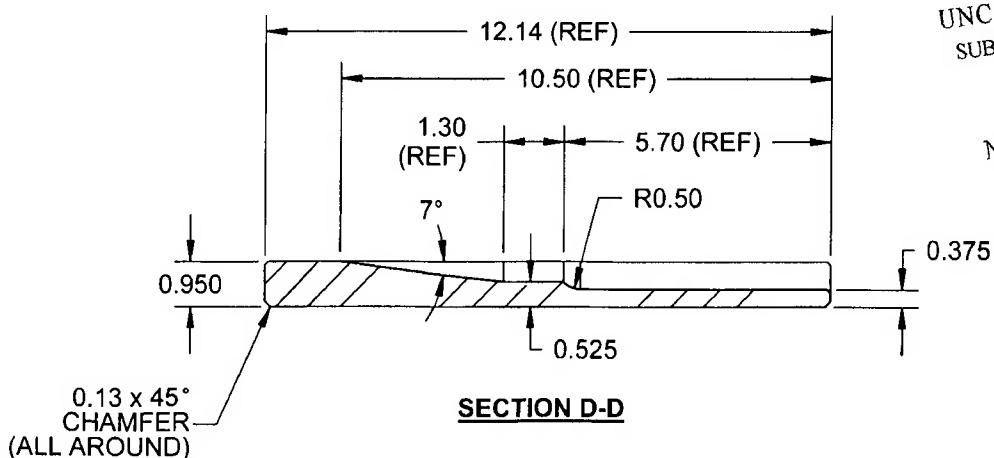
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04	TITLE R44 BEARPAW	SCALE 1:4	

RELEASED
07.03.22**SECTION A-A****SECTION B-B****SECTION C-C**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37315A*

**SECTION D-D**

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